Date

Wednesday, 6/27/2007 1:08:13 PM

User:

Process Sheet



Customer

: CU-DAR001 Dart Helicopters Services

: BUSHING **Drawing Name**

Job Number

: 33215

Estimate Number

: 10725 : NLA

P.O. Number

S.O. No. : NLA : 6/27/2007

Type

Part Number Drawing Number : D2652

This Issue Prsht Rev.

: 32987

: MACHINED PARTS

Project Number

: D2652 REV A

Drawing Revision

: N/A

Material

Due Date

: 7/10/2007

200 Um:

Each

Written By

Comment

First Issue

Previous Run

Checked & Approved By

: Est Rev:B **1**02.06.13

Now machined in house.

NG

Additional Product

Job Number: 17

5.3



Seq. #:

Machine Or Operation:

Description:

1.0

M303R0500

303 Round Bar 0.500"



Comment: Qty.:

0.0578 f(s)/Unit Total:

11.5500 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: M104919

2.0



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



4.0

QC8

Comment: SECOND CHECK

PACKAGING RESOURCE #1

PACKAGING 1 5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr QC Inspector					
		······································						
!		4						
Part No	:	PAR #: Fault Category:	NCR: Yes No DQA: Date: <u>07/08/</u> 03					

QA: N/C Closed: ____ Date: ____

NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)							
	_	Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
•					\$ P			
							· ·	

NOTE: Date & initial all entries

Date:

Wednesday, 6/27/2007 1:08:13 PM

User,: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33215

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C/N/07.08.0Z

Dart Ae	rospace L	td								
W/O:			W	ORK ORDER CHA	NGES			•		· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·			
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes 1	No DQ	A :	_ Date: _	
						QA: N	C Closed	d:	_ Date: _	;
NCR:			WORK ORD	ER NON-CONFOR	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Description	·		Verific Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date	CCCII), i O	Silici Ling	QO MOPCOLOI

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
DATE STEP Description of NC Corre			orrective Action Section B Verification					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
			-					
							100	
		•						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33215_
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototyp	е
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
· 0.600	+/-0.010	,599				
0.060	+/-0.005	.060 .304				
Ø0.305	-0.002/+0.000	:304				
Ø0.191	+0.005/-0.000	0191	<i>J</i> ,			
Ø0.500	+/-0.010	Hag				
0.030 x 20°	+/-0.010	030K50	V/			
R0.010	+0.010/-0.000	\$0.015				
					· · · · · · · · · · · · · · · · · · ·	
·						

	·					
		•.				

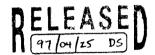
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 07 08 0	Date: 07-08, 01	Date:	

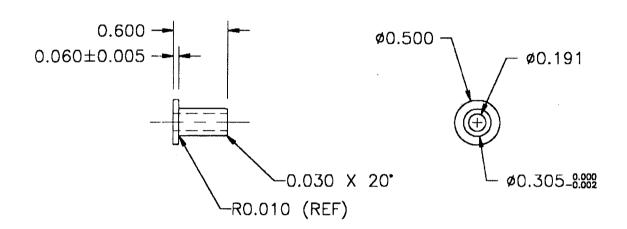
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	- 14
		A		





DESIGN	DRAWN BY	DART AEROSPACE FAIRCHILD INTERNATIONAL	
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	10/08	D2652	SHEET 1 OF 1
DATE.		TMLE	SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SHOPEDRY

RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE

3325